

These are several examples of Lean improvements from projects GEI consultants have led. Results vary based on many factors, but these examples are from actual projects.

- Changeover Reduction of 50% - \$1,250,000 cost avoidance in new equipment on critical path process.
- First-time yield improvement from 40% to 99%; changed handling method, which resulted in \$4,000,000 savings annually.
- Changeover Reduction of 62% - reduced need for one shift; transferred 7 employees to Value Adding Line jobs. Resulted in \$300,000 savings.
- Changeover Reduction of 77% - reduced in process WIP by 65% and increased floor space by 2200 square feet, which opened an area for a new value added accessory. Freed up \$1,200,000 of capital.
- Reduced non-value added inspection by 50%. Eliminated 50% of forklifts and drivers required in transporting product: resulted in \$135,000 savings.
- Reduced coil steel inventory by 85% - 46 days on hand was reduced to 4 days on hand which freed up \$5,000,000 in capital.
- Kaizen Event at food processing plant which reduced line changeover from 18 minutes to zero; 16% increase in output; 9% improvement in yield.
- First Time Yield improvement of 41%.
- Reduced non-value added inspection requirements by 50%.
- Kaizen Event found 60% of handling damage to the product was due to current material flow method. This created \$800,000 annual savings. Also avoided a \$3,000,000 capital proposal. Cost for improvement: \$6,000.
- Two teams combined for \$460,000 in annualized cost savings. In addition, the line we treated recorded a perfect production hour for the first time ever.
- Training went so well at a Kaizen Event, another machine was added to the project. The result was a \$180,000 savings to the plant, while the original line concurrently recorded a 97% efficiency ratio.
- Machine center changeover from 9 hours to 35 minutes – savings of \$300,000 per year. The plant spread it to 7 additional machines for a total savings of \$2,400,000.
- Filter plant – Maintenance Improvement \$200,000; Quality \$250,000; Downtime reduction of \$500,000.
- A containment project reduced PPM from 35,000 to 5,000 in six weeks.
- Improved machining center productivity by reducing defects, downtime and rebalancing the line. Total savings of \$2.1 million.
- Machine changeover from 4 hours to 5 minutes creating a savings of \$150,000 per machine; 10 machines at the plant.
- Improved plant operations using Lean Manufacturing. Total expected savings of \$6,000,000. Projects: visual management, flow, cell design, changeovers, 5-S, production planning, and supervisory training.
- One project recorded over \$8,000,000 in Lean savings in less than one year.

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